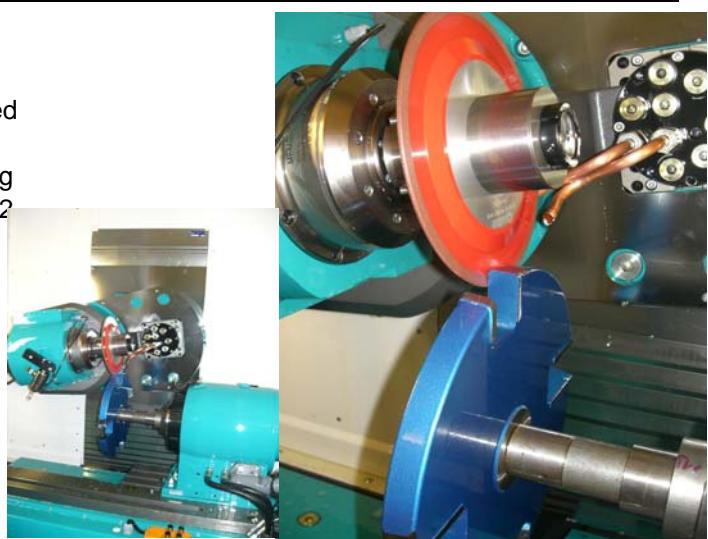


Profiled Cutter incl. limiters Ø280 Z4

A16-210

The woodworking profiled cutter head with alternately inclined cutting edges and limiting profile is ground in one setup. The tool has 4 cuttingedges, each of them has a steel limiting plate. In Quinto the tool is handled as 4 concatenated tools, 2 for the carbide profile and 2 for the limiting plate. Each of them is individually probed.



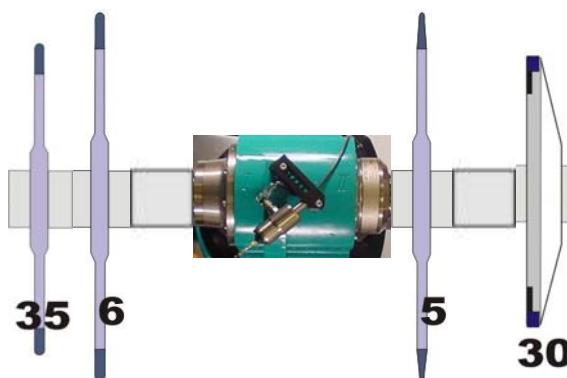
1. Cycletime for Production

Tool specifications Ø280, altern. Shear angles 10/-10°, L25 mm Material CARBIDE							
Operations	Probe	Flute 1	Prf Pregr 1	Prf Pregr 2	Prf fin	Prf Pregr HSS	Prf Fin HSS
Feed [mm/Min]	2000	65	60	70	90	60	90
Power [kW]		4	2	1	1	1	1
Cutting feed [m/s]		18	24	24	24	32	32
Used wheels		30	6	6	5	35	35
Grinding time [s]	32	507	359	342	311	357	318
Total cycle time	37 Min 5						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

30 Ø150 12C9 D64
6 Ø200 14F1 D64
5 Ø200 14EE1 D64
35 Ø150 14F1 B126



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR, NORMA CFG
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.3, DXQ

responsible engineer: OP,8.1.08

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TECHNOLOGY
FOR TOOLING